



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3319-1

Job Sheet 210002



Part No: D3319-1

Job Qty: 4 pcs

Part Name: Forward Wearplate



Part Weight: 0 lbs

Job Created: 5/21/20

Due Date: 5/29/20

Type: SOLD

Status: New

Job Tracking No:

Created By: Linda Lacelle

Description:

Note: IPP: B 05.10.14 Added step 9, dwg rev B KJ/EC IPP Rev: C Now on Waterjet 06-10-26 JLM IPP REV: D
17.10.25 AS PER DWG REV: D DD VERF: JFS

Ship Via:

POSITIVE RECALL

EFFECTIVE 20/05/21 AUTH SL

RELEASED D DATE 20-05-21

Priority: Medium

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
100	Waterjet - Flow - 1	4 pcs		5/28/20	0.17	0.42	Waterjet - Flow			20/05/21
							Waterjet - Omax			
110	QC 2	4 pcs		5/28/20	0.00	0.00	QC 2 - 1			20/05/21
							QC 2 - 12			
							QC 2 - 14			
							QC 2 - 17			
							QC 2 - 19			
							QC 2 - 2			
							QC 2 - 20			
							QC 2 - 22			
							QC 2 - 23			
							QC 2 - 25			
							QC 2 - 32			
							QC 2 - 33			
							QC 2 - 35			
							QC 2 - 39			
							QC 2 - 4			
							QC 2 - 40			
							QC 2 - 44			
							QC 2 - 45			
							QC 2 - 48			
							QC 2 - 49			
							QC 2 - 50			
							QC 2 - 51			
							QC 2 - 52			
							QC 2 - 57			
							QC 2 - 62			
							QC 2 - 63			
							QC 2 - 8			
							QC 2 - 66			

Plex 5/21/20 8:50 AM dart.lacelle.linda

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				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
				QC 2 - 83	
120 QC 8	4 pcs	5/28/20	0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
				QC 8 - 66	
				QC 8 - 73	
				QC 8 - 82	
140 Small Fab - Brake NC - B4B	4 pcs	5/28/20	0.25 0.29	Small Fab - Brake - 1 - B4B	
				Small Fab - Brake - 2 - B4B	
				Small Fab - Brake - 3 - B4B	
160 Automated Welding - B4B	4 pcs	5/28/20	0.00 1.03	Automated Welding - 1 - B4B	
170 QC 10	4 pcs	5/28/20	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	
				QC 10 - 43	
				QC 10 - 50	
				QC 10 - 58	
				QC 10 - 9	
				QC 10 - 68	
				QC 10 - 81	
180 QC 5	4 pcs	5/28/20	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	

DAS
MAY 21 2020 10:40
-89

MAY 22 2020

DAS
24
9-89

DAS
24
9-89

					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
					QC 5 - 82	DAS
190	Spray Paint - 2 - B4B	4 pcs	5/29/20	0.00 0.67	Spray Paint - 1 - B4B	41 MAY 26 2020
					Spray Paint - 2 - B4B	9-89
					Spray Paint - 3 - B4B	
					Spray Paint - 4 - B4B	
200	QC 3 QC 14 GCB MAY 27 2020	4 pcs	5/29/20	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	DAS
					QC 3 - 81	82
					QC 3 - 82	9-89
					QC 3 - 87	QC14-82 MAY 27 2020
210	Packaging 3-1 - Stock - B4B	4 pcs	5/29/20	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	DAS
					Packaging 3 - 6 - B4B	28
					Packaging 3 - 7 - B4B	9-89
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	

				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
220 QC 21 - SA	4	5/29/20	0.00 0.00	QC 21 - SA - 21	DAS
	pcs			QC 21 - SA - 70	21
				QC 21 - SA - 9	9-80
					MAY 27 2020

Part Op **100** - 1-Cut as per Dwg D3319 Dwg Rev: E Prog Rev: E 2-Deburr if necessary
 Descriptions: **110** - (QC2- Inspect parts off machine FAI/FAIB)
120 - QC8- Inspect parts - second check)
140 - (Form as per dwg) 1- Form using DT8326 & DT8261 as per Dwg D3319Rev: _____ 2- Form flat on press using DT8776 block
160 - 8259 HARDCOAT B: M139078
170 - (QC10- Inspect visual per QSI004- ground welds)
180 - (QC5- Inspect part completeness to step on W/O)
190 - Spray Paint / NDT Room) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURE COATING AS PER DWG NOTE 9 SHEET ONE. BATCH: 3276824
200 - (QC3- Inspect Part Finish)
210 - (Identify as per dwg & Stock Location: _____)Identify on inside surface using a permanent fine point marker with the following: TCCA-PDA, Dart Aerospace Ltd. P/N: D3319-1, B/N: BXXXXX For Product Eligibility see PDA05-18 and Stock Location: _____
220 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S18GA	304/316 .050 Sheet	2.5120 sf (.628 ea)	100-Waterjet - Flow - 1	5243464

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S18GA	3	199	0

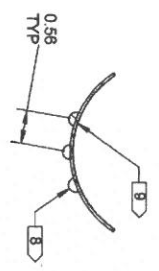
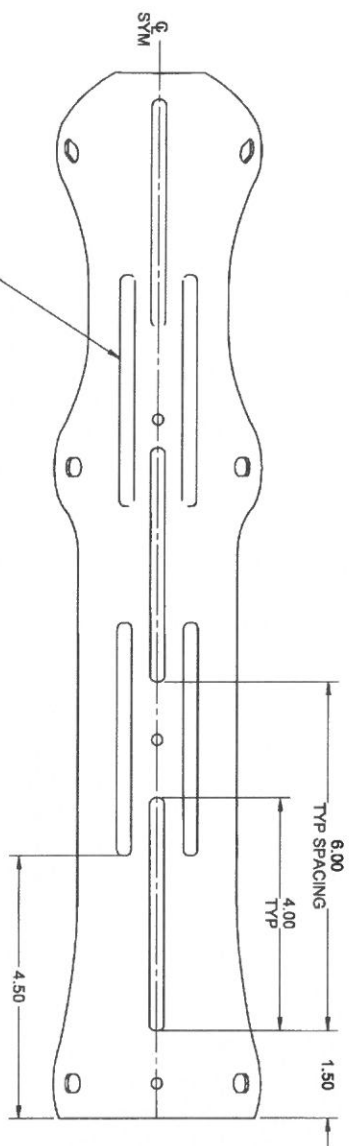
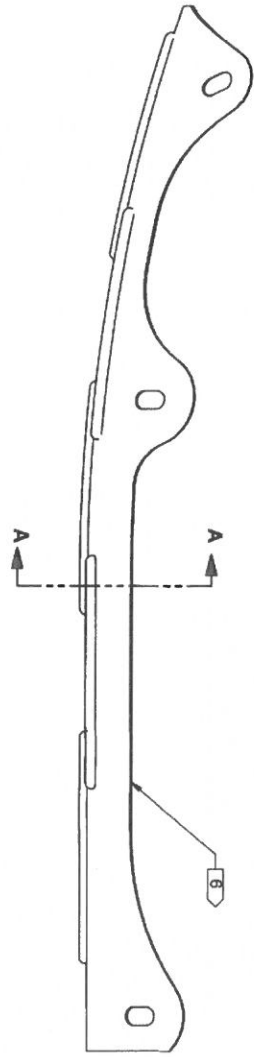
da Lacelle

From: Steven Drouin
Sent: Thursday, May 21, 2020 8:01 AM
To: Linda Lacelle
Subject: D3319

Hi Linda

Could you make a w/o for D3319 with Positive Recall on it that I will sign, so manufacturing could start working on the new rev for the order , I have a Signed copy of the New Revision by David, , the Drawing will be released today when Chris signs the ECN20-560.

Steven



D3319-1 WEARPLATE
MAKE FROM D3319-1BND

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3319-1" PER QSI 044 6.1
 - 7) WEIGHT: 1.08 lbs
 - 8) BUILDUP HARD SURFACING 0.06 TO 0.13 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR BUILDUP HARD SURFACING 0.06 TO 0.13 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)
 - 9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING 0.020-0.040 THICK, PER DART QSI 005 4.9

APPROVED

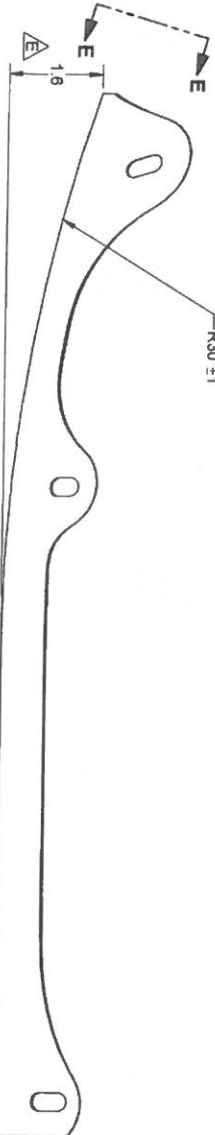
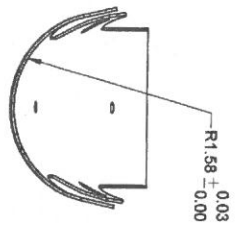
REV.	DESCRIPTION	DATE
E	MODIFIED D3319-1F FLAT PATTERN TO CORRESPOND TO OEM SKIDTUBE UPDATE. REASON CAR18-342	SAD 20.05.08
D	REVISE DRAWING TO SOLIDWORKS FORMAT. UPDATE NOTES, ADD ROBOTIC WELDING PROCESS. UPDATE TOLERANCES TO REFLECT INSPECTION CAPABILITY. ADD BREAK TO INSIDE OF HOLE. ADD MISSING DRAIN HOLES. D3319-1-3, CHANGE MTL TO SS 304/316, ADDED D3319-BND SECTION VIEW F-F, AND UPDATED VIEW E-E ADDED DETAIL D, 1:1	SAD 17.05.09
C	UPDATE TO CURRENT STANDARDS LAW QSI 045, CLOSED 17.05.09	MB 12.03.13
B	WIDEN HOLES, REDUCE WIDTH OF -3/4-7	PH 05.08.08
A	NEW ISSUE	PH 04.09.24
DESIGN	PH	
DRAWN	SAD	
CHECKED	KPT	
MFG. APPR.	DD	
APPROVED	VS	
DATE	20.05.08	

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

WEARPLATE

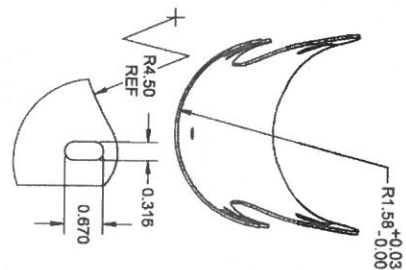
REV. E
SHEET 1 OF 8
SCALE
NTS

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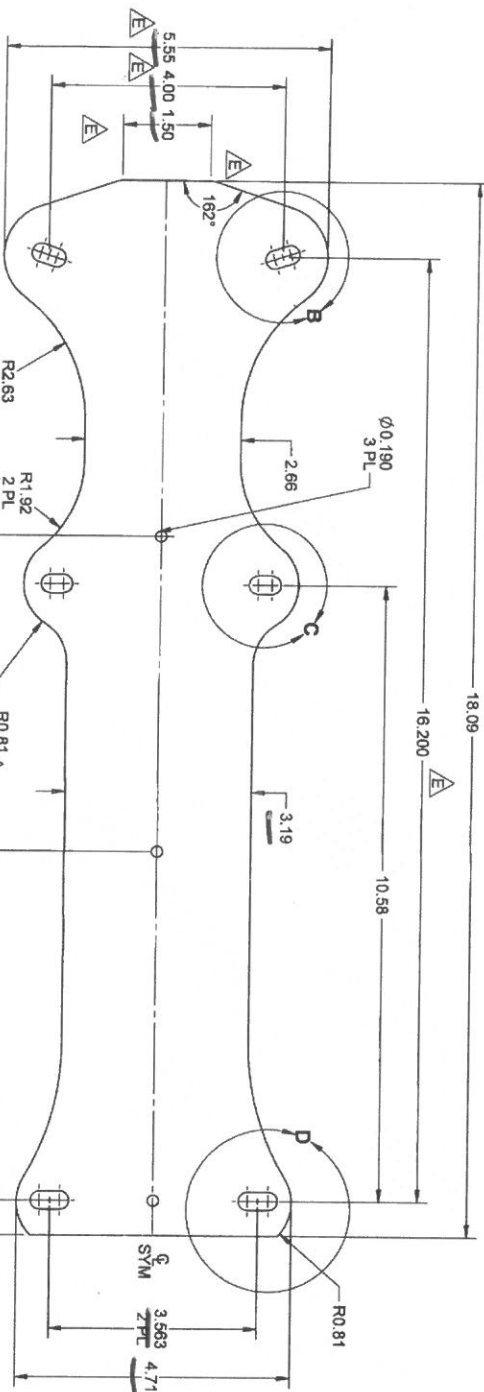


VIEW E-E

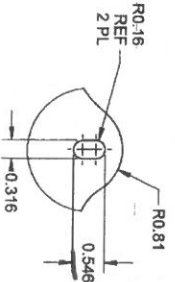
D3319-1BND WEARPLATE
MAKE FROM D3319-1F



DETAIL D
R0.16 REF
2 PL



DETAIL B
R0.81
2 PL



DETAIL C
R0.16 REF
2 PL

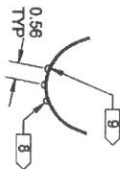
D3319-1F WEARPLATE
FLAT PATTERN

- NOTES:**
- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED, 18 GAUGE (0.048 THICK)
PER MIL-S-5059 OR AMS 5613 (304)
OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF PART SPEC M304S18GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER PART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.87 lbs
 - 8) FOR NON-DIMENSIONED FEATURES, REFER TO CAD FILE D3319-1F-REVE.DXF

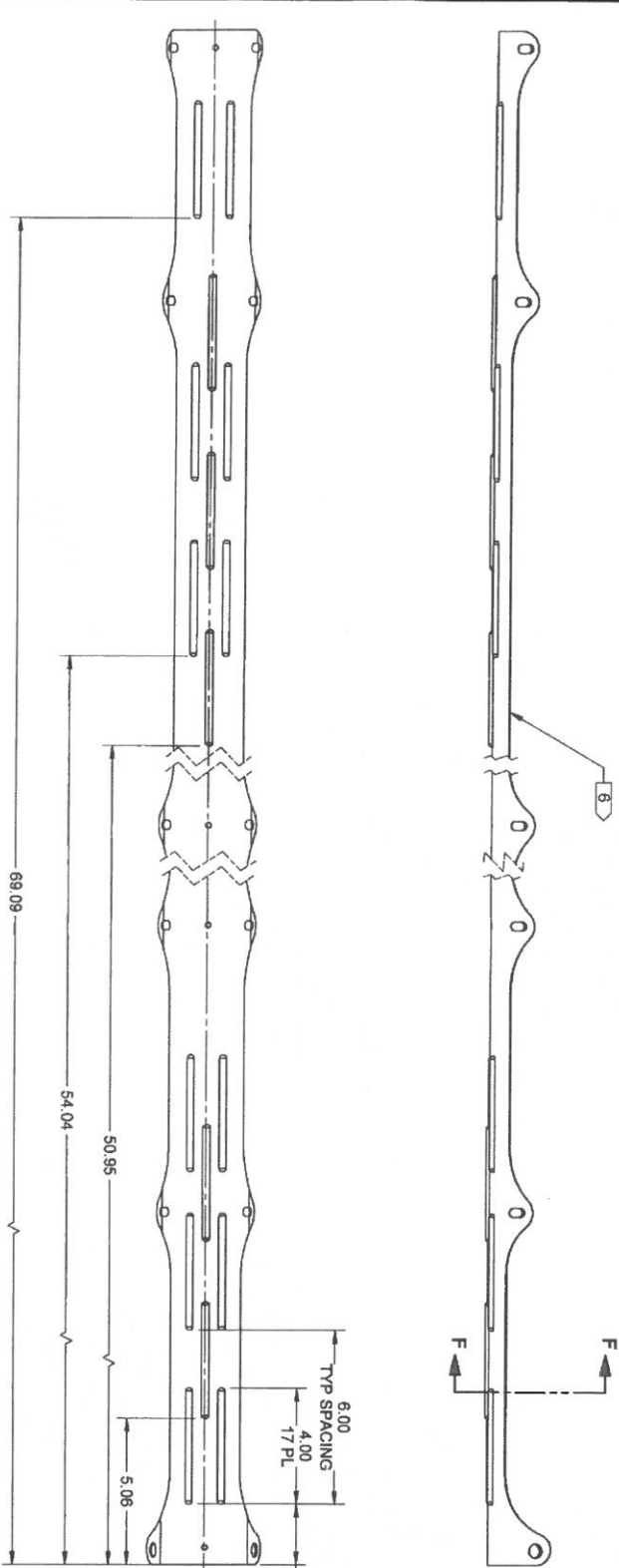
APPROVED

DESIGN	PH	SAAD	DART AEROSPACE LTD
DRAWN	SAAD		HAMKESBURY, ONTARIO, CANADA
CHECKED	KPT		DRAWING NO.
MFG. APPR.	DD		D3319
APPROVED	VS		SHEET 2 OF 8
DATE	DS		WEARPLATE
20.05.08			SCALE
			NTS

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SECTION F-F



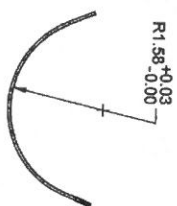
D3319-3 WEARPLATE
MAKE FROM D3319-3BND

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3319-3" PER OSI 044 6.1
 - 7) WEIGHT: 3.71 lbs
 - 8) BUILDUP HARD SURFACE 0.06 TO 0.13 THICK USING 8259 ROD PER OSI 004 SECTION 4.5 (AUTOMATED WELDING) OR BUILDUP HARD SURFACE 0.06 TO 0.13 THICK USING 2059B ROD PER OSI 004 SECTION 4.1 (MANUAL WELDING)
 - 9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING 0.020-0.040 THICK, PER DART OSI 005 4.9

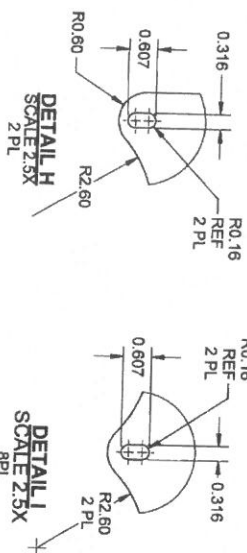
APPROVED

DESIGN	PH	DART AEROSPACE LTD
DRAWN	SHD	HAWKESBURY, ONTARIO, CANADA
CHECKED	KPT	DRAWING NO.
MFG. APPR.	DD	D3319
APPROVED	VS	TITLE
DATE	DS-#	WEARPLATE
20.05.08		SCALE
		NTS

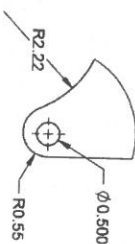
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SECTION G-G
SCALE 4X



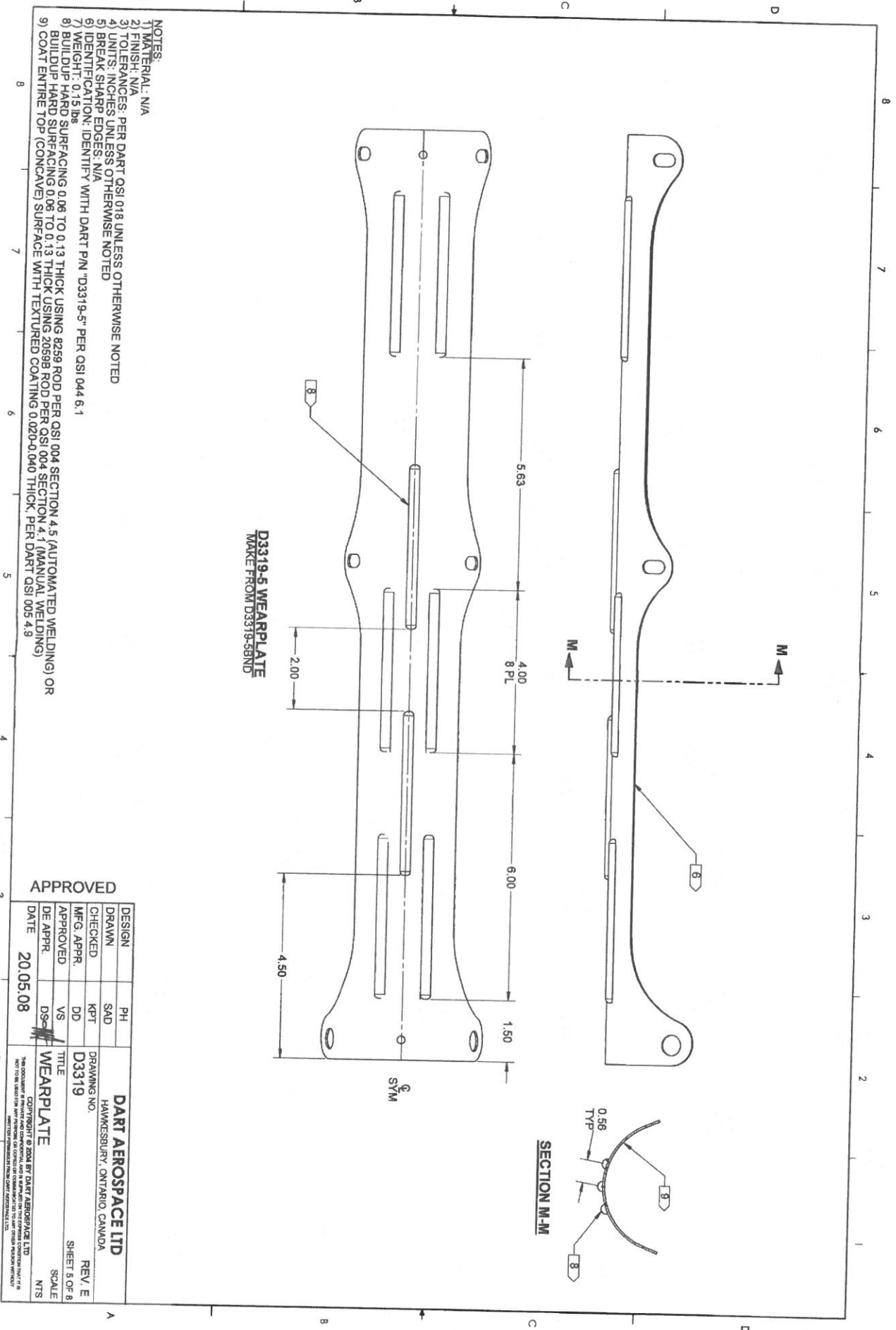
DETAIL J
SCALE 2.5X
2 PL



- APPROVED

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	SAD	HAMMERSBURY, ONTARIO, CANADA	
CHECKED	KPT	DRAWING NO.	REV. E
MFG. APPR.	DD	D3319	SHEET 4 OF 8
APPROVED	VS	TITLE	
DE APPR.	DS	WEARPLATE	
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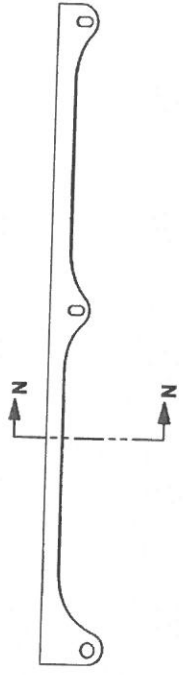
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- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3319-5" PER QSI 044 6.1
 - 7) WEIGHT: 0.15 lbs
 - 8) BUILDUP HARD SURFACING 0.08 TO 0.13 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR 20598 ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)
 - 9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING 0.020-0.040 THICK, PER DART QSI 005 4.9

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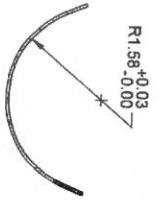
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CHECKED	KPT	DRAWING NO.
MFG. APPR.	DD	D3319
APPROVED	VS	TITLE
DATE	DS	WEARPLATE
20.05.08		SCALE
		NTS

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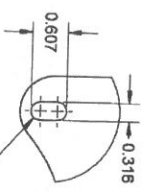
D3319-5BND WEARPLATE
MAKE FROM D3319-5F



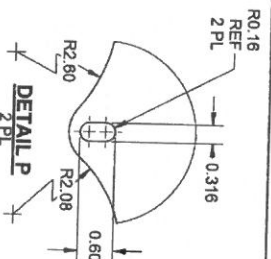
SECTION N-N
SCALE 2X



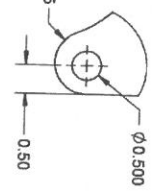
DETAIL O
2 PL



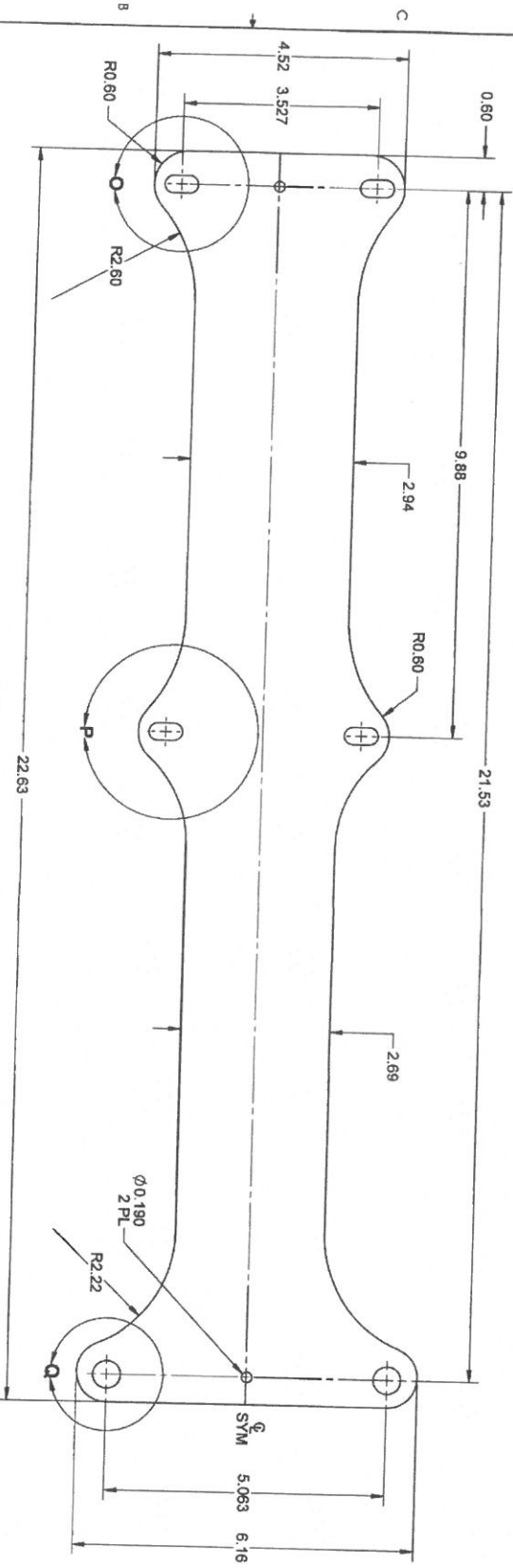
DETAIL P
2 PL



DETAIL Q
2 PL



D3319-5F WEARPLATE
FLAT PATTERN



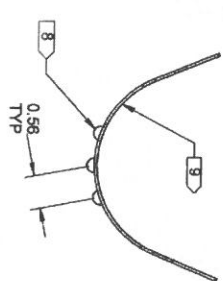
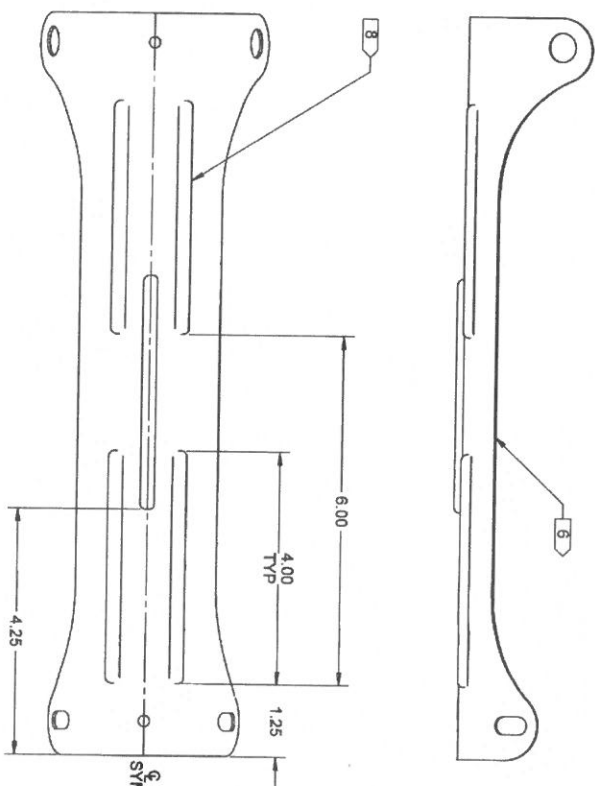
NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 18 GAUGE (0.048 THICK)
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR
ASTM A240 OR ASME SA240 18 GAUGE (0.048 THICK)
REF DART SPEC M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.15 lbs
- 8) FOR NON-DIMENSIONED FEATURES, REFER TO CAD FILE D3319-5F-REVE.DXF
- 9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING 0.020-0.040 THICK, PER DART QSI 005 4.9

APPROVED

DESIGN	PH	DART AEROSPACE LTD
DRAWN	SAD	HAMMERSBURY, ONTARIO, CANADA
CHECKED	KPT	DRAWING NO.
MFG. APPR.	DD	D3319
APPROVED	VS	REVE
DE APPR.	DS	SHEET 8 OF 8
DATE	20.05.08	WEARPLATE
		SCALE
		NTS

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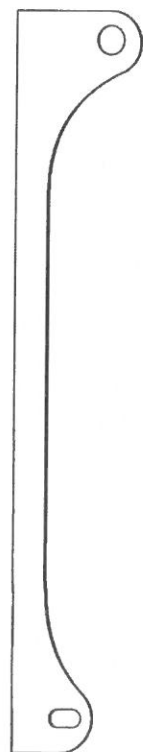
D3319-7 WEARPLATE
MAKE FROM D3319-7BND

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3319-7" PER OSI 044 6.1
 - 7) WEIGHT: 0.71 lbs
 - 8) BUILDUP HARD SURFACING 0.06 TO 0.13 THICK USING 8259 ROD PER OSI 004 SECTION 4.5 (AUTOMATED WELDING) OR BUILDUP HARD SURFACING 0.06 TO 0.13 THICK USING 20598 ROD PER OSI 004 SECTION 4.1 (MANUAL WELDING)
 - 9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING 0.020-0.040 THICK, PER DART OSI 005 4.9

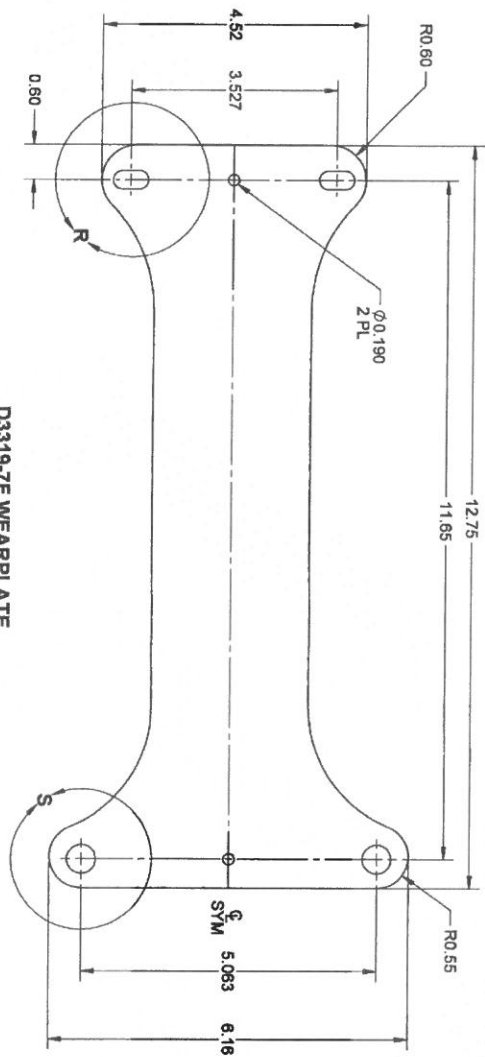
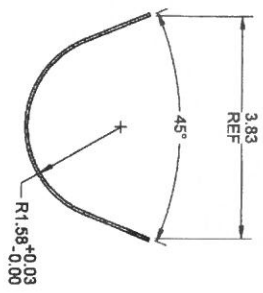
APPROVED

DESIGN	PH	DART AEROSPACE LTD
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA
CHECKED	KPT	DRAWING NO. D3319
MFG. APPR.	DD	REV. E
APPROVED	VS	SHEET 7 OF 8
DE APPR.	DS-#	SCALE
DATE	20.05.08	NTS
WEARPLATE		

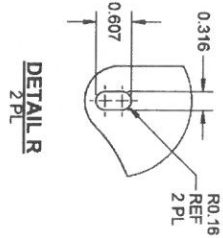
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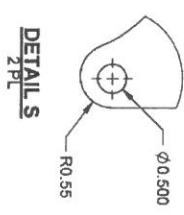
D3319-7FND WEARPLATE
MAKE FROM D3319-7F



D3319-7F WEARPLATE
FLAT PATTERN



DETAIL R
2 PL



DETAIL S
2 PL

- NOTES:**
- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 18 GAUGE (0.048 THICK)
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR
ASTM A240 OR ASME SA240
REF DART SPEC M304S18GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.71 lbs
 - 8) FOR NON-DIMENSIONED FEATURES, REFER TO CAD FILE D3319-7F-REVE.DXF

APPROVED

DESIGN	PH	DART AEROSPACE LTD
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA
CHECKED	KPT	DRAWING NO.
MFG. APPR.	DD	D3319
APPROVED	VS	TITLE
DATE	DS	WEARPLATE
20.05.08		SCALE
		NTS

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